Work Order October-25-11 3:08			*755	575*		_	The) (No.	N. Jar	Page 1
Item ID: D3 Revision ID:	3348-1	A	Accept	*N900	040	100)* s	Setup S	tart	*NS	31*
Item Name: Cle	evis							S	top	*NS	32*
Start Date: 25/ Required Date: 08/ Reference:	/10/2011 Start Qty: 12.00 /11/2011 Req'd Qty: 12.00	*12* *12*		Cust Item I Customer:	D:						17
	rocess Plan: M.L.J	Date: 11/10/25	Tooling:	Dε	ıte:	-	F		tart	*NF	R1*
Q	C:	Date:	SPC (Y/N):	Da	ıte:			S	top	*NF	? 2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty			Insp. Stamp
Draw Nbr	Revision Nbr						-				
D3348	Rev B										
*100 *100 Waterjet FLOW CNC Waterjet	FLOW WATER JET Memo 1-Cut as per Deburr if ne	Dwg D3348 Dwg Rev:cessary (\$\(\(\(\(\) - \(\) \)	0.00 0.00 Prog Rev:	<u>}</u> 2-			压1	(-(0)-	25_	()3	
*110	QC2- Inspect parts off r	nchine FAI/FAIB	0.00	·			يما	11 <u>-10</u>	. 7.1		
QC Quality Control	Мето		0.00					11_16_			
120	QC8- Inspect parts - seco	and check	0.00			•	ount	D			
120 QC Quality Control	Мето		0.00 0 " (1	0/28			(\$23))			

Dart	Aeros	pace	Ltd
------	--------------	------	-----

W/O:			WC	RK ORDER CHANG	ES			
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Q	Approval Chief Eng / Prod Mgr	Approval QC Inspector
·								
Part No	:	PAR #:	Fault Cated	jory:	_ NCR: Yes I	No DQA:_	Date: _	
		esolution:						
NCR:		-	WORK ORDI	R NON-CONFORMA	ANCE (NCR))		
DATE	STEP	Description of NC		Corrective Action Secti		Verification	on Approval	Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		QC Inspector
								:

Work Orde October-25-11		575		*75!	575*						Page 2
Item ID: Revision ID:	D3348-1			Accept	*N900	040	100)* s	etup Start	171.	S1*
Item Name:	Clevis								Stop	*N:	S2*
Start Date: Required Date: Reference:	25/10/2011 08/11/2011	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item I Customer:	D:					
Approvals:	Process Pla	ın:	Date:	Tooling:	Da	ate:	-	R	un Start	*N	R1*
••	QC:		Date:	SPC (Y/N):		ate:			Stop	ı	R2*
Sequence ID/ Work Center II	D	Operation Description Small Fab		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab		Memo Deburr		0.00	W/A						
140		NC BRAKE		0.00	\	(6)		23			
140 Brake NC Brake NC		Memo Form as per	Dwg D3348	0.00	S. ((\(1)	.					
150		QC5- Inspect part comple	eteness to step on W/O	0.00							. /
150 QC		Memo		0.00				<u> </u>	11_	_11_	0/6

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
			•				

Part No:		PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:			WORK ORDE	ER NON-CONFORMANC	E (NCR)			
		Description of NC		Corrective Action Section B		Verification	Annroyal	Annuaral
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector

								-
- 18	1							

Work Order ID 75575 *75575* October-25-11 3:08:28 PM Item ID: D3348-1 Accept *N900040100* Setup Start **Revision ID:** Clevis Item Name: **Start Qty: 12.00 Start Date:** 25/10/2011 **Cust Item ID: Required Date: 08/11/2011** Req'd Qty: 12.00 **Customer:** Reference: Run Date: Approvals: **Process Plan: Tooling:** Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool# Plan Reject Reject Accept **Work Center ID** Description Run Hours Qty Number Stamp Code Qty Identify as per dwg & Stock Location: 160 0.00 *160* Packaging 0.00 Memo Packaging *****STOCK IN BASKET CELL*****

170

QC21- Final Inspection - Work Order Release

0.00

170

Quality Control

Memo

0.00

Insp.

Page 3

	•								
W/O:			WO	RK ORDER CHANG	ES				<u></u>
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
2.2.									
Part No		PAR #:							
	Re	esolution:	Disposition		_ QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC		Corrective Action Secti		Verific	cation	Approval	Approval
DAIL	JIL!	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti	ion C	Chief Eng	QC Inspector
									
			1 1		1				

Picklist Print

October-25-11 3:08:32 PM

Work Order ID: 75575

75575

Parent Item: D3348-1 *D3348-1*

Parent Item Name: Clevis

Start Date: 25/10/2011

Required Date: 08/11/2011

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP: A05.02.09New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S12GA		Purchased	No			100	sf	32.0000	0.0182	0.229895	;		
*140400	100 1 *								**	. ~ .			

*M1()1()\$12(3A³ 1010/102 mild steel sheet 12ga

Location Loc Qty Loc Code MAT019 32 110933 32

110933

W/O:			WO	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHAN	IGE	1	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cated	orv.	NCR:	Yes N		Δ.	Date:	
		olution:								
NCR:		,	WORK ORDE	R NON-CONFORMA	ANCE (NCR)				
DATE	STEP	Description of NC Section A	Initial	Action Description	ion B	Sign &		cation ion C	Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng		Date				
										

DART AEROSPACE LTD	Work Order:	75575
Description: Clevis	Part Number:	D3348-1
Inspection Dwg: D3348 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
-----------------	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.266	+0.006/-0.001	266	£		U MOZ	
0.900	+/-0.010	519	2		V	
2.919	+/-0.010	159.6	>-		V	
2.019	+/-0.010	2,620	2		1/	
0.450	+/-0.010	, 446	7		<i>y</i>	

				-		
	,					
	1					
		<u> </u>				

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 11-10-75	Date: 11/10/25	Date:	N/A

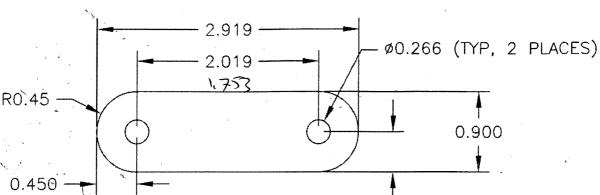
i	Rev	Date	Change	Revised by	Approv	/9/d
	Α	06.09.01	New Issue	KJ/JLM		

	-									
W/O:			WO	RK ORDER CHANGE	S					
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
			,							
				•	·-					
				· .						
				·				·		
Part No:			Fault Category: NC					Date:		
	Res	solution:	Disposition	:	QA: N/C	Closed:		Date: _		
NCR:			WORK ORDE	R NON-CONFORMAN	ICE (NC	R)				
DATE	STEP	Description of NC	Corrective Action Section B			Sign & Verifica		tion Approval	Approval	
		Section A	Initial Chief Eng	Action Description Chief Eng	Dat		on C	Chief Eng	QC Inspector	
				·						
				· · · · · · · · · · · · · · · · · · ·						



DESIGN	ORAWN BY		EROSPACE LTD JRY, ONTARIO, CANADA
CHECKE	D APPROVED	DRAWING NO.	REV. B
d	H- #	D3348	SHEET 1 OF 1
DATE		TITLE	SCALE
05.03	5.04 ·	CLEVIS	1:1
Α	04.11.11	NEW ISSUE	

INSIDE RADIUS WAS RO.13, NOW RO.03

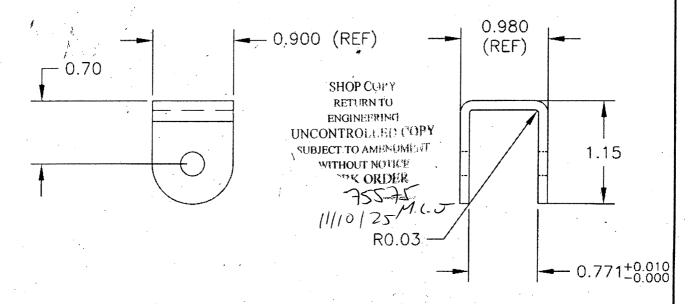


0.450 -

05.03.04

В

FLAT PATTERN



BENDING DETAIL

D3348-1 CLEVIS

AISI 1010-1025 OR ASTM A36/A366/A1008 OR 1) MATERIAL:

CSA G40-21,38W/44W/50W/60W/70W SERIES STEEL 12 GAUGE (0.105 THICK)

(REF DART SPEC: M1010-S12GA)

- 2) ALL DIMENSIONS ARE IN INCHES
- 3) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Dail AC	Dait Aerospace Liu										
W/O:			WORK ORDER CHANGES								
DATE	STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
			·								
				L							
Part No	:	PAR #: _	Fault Category:	NCR: Y	es No DQ	A:	Date: _				
	Re	solution:	Disposition:	QA: N/C	Closed:		Date: _				

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date					
							`			
-					 		<i>;</i>			
	-									
				/						
L								1		